"Teamwork & Communication"

Model GX-7 Spray Gun
Operating Manual
16943-1

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NOTICE: This manual contains important information for your GUSMER equipment. Read and retain for future reference.
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WARRANTY

Gusmer Corporation (Gusmer) provides a limited warranty to the original purchaser (Customer) of Gusmer manufactured parts and equipment (Product) against any defects in material or workmanship for a period of one year from the date of shipment from Gusmer facilities.

In the event Product is suspected to be defective in material or workmanship, it must be returned to Gusmer, freight prepaid. If Product is found to be defective in material or workmanship, as determined solely by Gusmer, Gusmer will issue full credit to Customer for the freight charges incurred in returning the defective Product, and either credit will be issued for the replacement cost of the Product or a replacement part will be forwarded no-charge, freight prepaid to Customer.

This warranty shall not apply to Product Gusmer finds to be defective resulting from: installation, use, maintenance, or procedures not accomplished in accordance with our instructions; normal wear; accident; negligence; alterations not authorized in writing by Gusmer; use of “look alike” parts not manufactured or supplied by Gusmer; or Product used in conjunction with any other manufacturer's pumping or proportioning equipment. Further, the terms and conditions of this warranty shall not apply to services or repairs made to Product by any third party not authorized in writing by Gusmer. For such Product, a written estimate will be submitted to Customer at a nominal service charge, itemizing the cost for repair. Disposition of Product will be done in accordance with the terms stated on the written estimate.

The warranty provisions applied to product that are not manufactured by Gusmer will be solely in accordance with the warranty provided by the original manufacturer of the product.

GUSMER MAKES NO WARRANTY WHATSOEVER AS TO THE MERCHANTABILITY OF, OR SUITABILITY FOR, ITS PRODUCT TO PERFORM ANY PARTICULAR PURPOSE. CREDIT FOR, OR REPLACEMENT OF, PRODUCT DEFECTIVE IN MATERIAL OR WORKMANSHIP SHALL CONSTITUTE COMPLETE FULFILLMENT OF GUSMER OBLIGATIONS TO CUSTOMER. NO OTHER WARRANTY, EXPRESS OR IMPLIED ON ANY PRODUCT IT MANUFACTURES AND/OR Sells, WILL BE RECOGNIZED BY GUSMER UNLESS SAID WARRANTY IS IN WRITING AND APPROVED BY AN OFFICER OF GUSMER.

Under no circumstances shall Gusmer be liable for loss of prospective or speculative profits, or special, indirect, incidental or consequential damages. Further, Gusmer shall have no liability for any expenses including, but not limited to personal injury or property damage resulting from failure of performance of the product, use of the product, or application of the material dispensed through the product. Any information provided by Gusmer that is based on data received from a third source, or that pertains to product not manufactured by Gusmer, while believed to be accurate and reliable, is presented without guarantee, warranty, or responsibility of any kind, expressed or implied.

Gusmer through the sale, lease, or rental of Product in no way expresses or implies a license for the use of, nor encourages the infringement of any patents or licenses.

To insure proper validation of your warranty, please complete the warranty card and return it to Gusmer within two weeks of receipt of equipment.

Revised 11/12/98
GENERAL SAFETY INFORMATION

It is necessary to understand and follow the instructions in this manual to ensure proper and safe operation of the equipment.

As with most mechanical equipment, certain safety precautions must be taken when the equipment discussed in this manual is operated or serviced. Severe bodily injury or damage to equipment and property may result if the instructions and precautions listed throughout this manual are not followed.

Needless to say, sufficient guidelines cannot be developed to eliminate the need for good common sense in the use and servicing of this equipment, and in the use and application of the products, this equipment has been designed to process. Users of this equipment must therefore, make their own determination as to the suitability of the information contained in this manual to their specific operation and requirements. There should be no assumption made that the safety measures and instructions contained herein are all-inclusive, and that other safety measures may not be required for specific use or application.

The following safety guidelines are generally applicable to the safe and efficient use of the equipment.

Acceptable Equipment Uses

The equipment is designed for the dispensing of polyurethane foams, two-component coating systems, and some two-component epoxy systems, specifically polyureas. Under no circumstances should any acid or corrosive chemicals be used in the unit. Consult GUSMER if there is any doubt about the compatibility of the chemical system to be used in this equipment.

Any use of this equipment other than as indicated above constitutes misuse unless express written approval is obtained from GUSMER.
Operational Safety Procedures

This safety information will not be repeated in the text of this manual. The symbols pertaining to this information will appear where appropriate to alert the operator to potential hazards.

**WARNING:** The solvents and chemicals used with this equipment expose the operator to certain hazards. Adequate personal protective measures must be taken so as to avoid exceeding the Threshold Limit Value (TLV) of the products being used, as established by the Occupational Safety and Health Administration (OSHA) or other qualified agency. Obtain information concerning personal protection and proper handling from the supplier of such chemicals.

**WARNING:** To prevent serious bodily injury from electrical shock, never open the electric consoles or otherwise service this equipment and/or equipment used with it before switching off the main power disconnect and interrupting supply voltage at the source. The electrical service must be installed and maintained by a qualified electrician.

**WARNING:** This equipment has or is used with equipment that has hydraulic components capable of producing up to 3500 psi. To avoid serious bodily injury from hydraulic injection of fluid, never open any hydraulic connections or service hydraulic components without bleeding all pressures to zero.

**WARNING:** To avoid serious bodily injury, proper protective gear must be worn when operating, servicing, or being present in the operational zone of this equipment. This includes, but is not limited to, eye and face protection, gloves, safety shoes, and respiratory equipment as required.

**WARNING:** This equipment has or is used with equipment that has high temperature components such as primary heaters and heated hoses. To prevent serious bodily injury from hot fluid or hot metal, never attempt to service the equipment before allowing it to cool.

**WARNING:** Failure to read and follow this safety information may result in personal injury and/or damage to the equipment from one or more of the above listed hazards.
DESCRIPTION

General Description

The design and development of the Gusmer Model GX-7 Spray Gun represents a milestone in engineering design so unique that it sets the standard by which all other guns are measured.

The GX-7 was designed for the professional applicator, providing a gun that has superior mixing capabilities and that is:

- Easy to operate and maintain
- Inexpensive to service
- Exceptionally versatile - uses a wide range of field-proven components to spray urethane foam, coatings, and mildly abrasive systems.

Although new and unique in many aspects, the gun employs the original Gusmer concept of impingement mixing through the use of a single-part MIXING MODULE. This system is efficiently and reliably cleaned by our patented mechanical self-cleaning process, eliminating the need for solvent or air purging between dispenses.

The GX-7 is lightweight, perfectly balanced, and incorporates the Gusmer original Quick Disconnect Coupling Block.

The gun can be assembled with two styles of mixing components; their selection is dependent upon the type of system sprayed. Several of the more common sets of these configurations are listed in the Appendix section of your parts identification manual. For additional combinations or specialty applications, contact your Authorized Gusmer Distributor or the Gusmer Sales Department.

One of the several technical advantages of the GX-7 gun is the innovative use of an efficient, durable Mixing Module in combination with a Pattern Control Disc to produce thoroughly mixed chemical and reliable spray patterns. The Module can be set up to spray at its maximum rated output, and by changing to a smaller Pattern Control Disc, can also spray at the low outputs and pressures required for detail work.
The Front Packing and Rear Packing are the only centerline components that require routine replacement. These inexpensive plastic parts wear during normal use and can generally be discarded when servicing. The Mixing Module is precision made from a specialty plastic and, with proper care during servicing, can be cleaned and reused through thousands of pounds of chemical. The hardened stainless steel Valving Rod is precision ground and polished and should not need routine replacement.

Considerable time has been spent evaluating the field performance of the GX-7 Gun. The assessment of the gun’s performance has culminated in a design that is easy, reliable, and as trouble-free as possible. However, do not assume that the gun will operate and maintain itself. A thorough understanding of this manual, along with the experience gained in using the gun, will provide you with the knowledge required to operate the gun properly.

Gusmer and our Authorized Distributors have experienced, highly qualified technical representatives who are always available to help you when a problem occurs. In most cases, a telephone conversation with these technical representatives will provide you with a solution to any problem.

Before proceeding with the following procedures, familiarize yourself with the parts of the GX-7 Gun (Figure 2), so that you may relate to them as you read this manual.

**FIGURE 2. MODEL GX-7 SPRAY GUN COMPONENTS**

1. Valving Rod Rear Stop  
2. Valving Rod Forward Stop  
3. Forward Stop Locknut  
4. Air Cap Valve  
5. Manual Valves  
6. Trigger  
7. Rear Packing Nut  
8. Gun Block Assembly
Before proceeding with the following procedures, familiarize yourself with the parts of the GX-7 Gun Block Assembly (Figure 3), so that you may relate to them as you read this manual.

**FIGURE 3. GUN BLOCK ASSEMBLY**

1. Air Cap
2. PCD Retainer
3. O-Ring
4. Pattern Control Disc
5. PCD Body
6. Front Packing
7. Mixing Module
8. Coupling Block Gasket
9. Rear Packing Retainer
10. Rear Packing
11. Packing Nut
12. Valving Rod
13. Check Valve Assembly
14. Screen
15. Screen Screw Seal
16. Resin Screen Screw
17. Iso Screen Screw
Equipment Supplied

The following tools (Figure 4) are supplied with the GX-7 gun

**NOTE:** In addition to the tools shown you will need an Adjustable Wrench and a flush can or a service block.

1. Gasket Removal Tool
2. 5/8" Wrench
3. 5/64 Drill (GX-7-400 ONLY)
4. 3/8" Wrench
5. 5/16" Spintite
6. 1/4" Hex Key Wrench
7. 3/16" Hex Key Wrench
8. Cleanout Brush
9. GX-7 PCD Tool (GX-7-400 ONLY)
10. Retainer Wrench
11. Impinger Cleanout Brush
12. Pin Vise
13. Cleanout Drill
14. 5/32" Cleanout Drill
OPERATION

Safety Position of Gun

The GX-7 gun has a two position Valving Rod Rear Stop (Figure 5). The SERVICE position allows for minimal rearward travel of the Valving Rod but will not allow chemical to discharge. The OPEN position allows full rearward travel of the Valving Rod and permits the Gun to dispense.

Whenever the gun is not spraying, it should be set to the SERVICE position.

FIGURE 5. SAFETY POSITION OF THE GUN

Closing the Manual Valves (Figure 6) prevents chemicals in the heated hoses from entering the gun. For the safety of the operator, close the Manual Valves before servicing the gun.

FIGURE 6. MANUAL VALVES
A Quick Disconnect Air Coupling has been provided for the Air Line. Gusmer recommends disconnecting the Air Line when transporting the gun while connected to the Heated Hose.

**WARNING:** WHEN THE GUN IS NOT BEING USED, ALWAYS SET THE REAR STOP TO THE SERVICE POSITION, AND CLOSE BOTH MANUAL VALVES. THIS IS TO AVOID THE POSSIBILITY OF PROPERTY DAMAGE OR BODILY INJURY FROM THE ACCIDENTAL OPERATION OF THE GUN.

**IMPORTANT:** Substitution of parts not designed or recommended by Gusmer could result in harm to the user and/or damage to the GX-7 Gun. Any alterations to or substitutions for Gusmer parts would void the warranty provisions set forth elsewhere in this manual.

**Operating Procedures**

The operational success of the mechanical self-cleaning feature in the GX-7 Gun is the degree of efficiency with which the mixing components are purged of mixed material. It is absolutely essential that the Valving Rod makes positive contact with the internal radius of the Pattern Control Disc (Figure 7) to completely purge this area of mixed material when the Valving Rod moves forward to the closed position, as shown. To develop the proper contact, the gun has an adjustable Forward Stop. Take care when making this adjustment since too much contact may cause excessive component wear or premature failure, and too little contact may cause pattern deformation or sticking.

![Figure 7. FORWARD STOP ADJUSTMENT](image)

**FORWARD STOP ADJUSTMENT**

1. SET THE REAR STOP TO THE SERVICE POSITION - to set the Service Position, push in the Rear Stop.

2. CLOSE BOTH MANUAL VALVES - use the 5/16 Spintite Wrench and turn each valve fully clockwise to close.

3. PRESSURIZE THE AIR CYLINDER - connect the Air Line from the gun to the air source and pressurize the Air Cylinder to the closed position.
4. **LOOSEN THE FORWARD STOP LOCKNUT** (Figure 8) - use the 5/16 Spintite Wrench and loosen the Locknut.

5. **ADJUST THE FORWARD STOP** (Figure 9) - use the 5/8 Open End Wrench and completely loosen (full CCW) the Forward Stop. Now slowly tighten (CW) the Stop Nut until a snug resistance is felt. From this point, reverse and loosen approximately 1/6 of a turn.

**NOTE:**
As a reference point, the movement of one wrench flat corresponds to 1/6 turn.

6. **TIGHTEN THE FORWARD STOP LOCKNUT** (Figure 10) - take care not to overtighten. If the Locknut bottoms out before some resistance is felt, replace the plastic friction plug.
Start-Up

1. ADJUST THE AIR CAP VALVE- use the 5/16 Spintite Wrench to adjust the air. Proper adjustment will be determined from experience. Too much air will cause pattern deformation and too little air will not keep the Pattern Control Disc clean. As a starting position try approximately 1/6 turn from the off (Fully Clockwise) position.

   NOTE:
   Use caution not to overtighten.

2. ADJUST THE REAR PACKING NUT- tighten the Rear Packing Nut by hand until it bottoms on the Packing and continue until the nut is finger tight. Use a 1/2” wrench to control weepage as required, slight weepage is acceptable.

   NOTE:
   Do not overtighten, this may cause sticking and undue packing wear.

3. OPEN BOTH MANUAL VALVES- turn each valve fully counterclockwise to open.

4. SET THE REAR STOP TO THE OPEN POSITION- to set the OPEN position, rotate the Rear Stop counter clockwise and allow the Stop to move into the open detente. (Refer to Safety Position section)

5. TEST SPRAY OFF TARGET.

Shutdown

1. SET THE REAR STOP TO THE SERVICE POSITION.

   NOTE:
   If the gun has been operating properly, it is not recommended that it be disassembled each day. However, it is recommended that the optional Service Block be used to service the gun without disassembly following the Flushing Procedures described in this manual.

2. CLOSE BOTH MANUAL VALVES.
SERVICING PROCEDURE

Valving Rod Removal

1. CLOSE BOTH MANUAL VALVES.

2. FLUSH THE GUN BLOCK- follow the Flushing Procedures described in this manual.

3. LOOSEN THE REAR PACKING NUT.

4. REMOVE THE REAR STOP- press the Stop partially forward, rotate it to the full counter clockwise position, and slide the Stop off the Air Cylinder.

5. REMOVE THE VALVING ROD- depress the Trigger Lever and hold. While the gun is open, use the 5/16 Spintite Wrench and unthread the Valving Rod Shaft (Figure 11). Remove the shaft and Valving Rod by hand.

6. VALVING ROD- inspect the Valving Rod for damage and replace as required. Clean and remove any buildup of mixed material from the Rod using a cloth soaked in Gun Cleaner or a fine steel wool.

Mixing Module Removal

1. SET THE REAR STOP TO THE SERVICE POSITION.

2. LOOSEN BOTH MANUAL VALVES.

3. REMOVE THE AIR CAP (Figure 12) - turn off air supply to the Air Cap and unthread the Cap from the PCD Body by hand.

4. FLUSH THE GUN BLOCK- follow the Flushing Procedures described in this manual.
5. REMOVE THE PATTERN CONTROL DISC- trigger the gun to the SERVICE position and unthread the PCD Retainer using an adjustable wrench. Remove the PCD. Clean the air ports in the Retainer using the #58 drill.

NOTE: If the Valving Rod is changed, it is recommended that the Forward Stop be reset.

6. VALVING ROD- inspect the Valving Rod for damage and replace as required. Clean and remove any buildup of mixed material from the Rod using a cloth soaked in Gun Cleaner or a fine steel wool.

NOTE: Ensure that the tool size matches the Module size used.

7. CLEAN THE MIXING MODULE- the Mixing Module is made of a specialized plastic material and may be damaged when serviced using the wrong type and size cleaning tools. The Module is a replaceable part, however, by carefully following the proper procedures, considerably extends its service life.

   a) Insert the Cleanout Tool, which came with the Module into the Pin Vise. The tool should be inserted so that its end bottoms in the Pin Vise before the Lock Collar is tightened

   b) Clean the Module ports by inserting in the Cleanout Tool. Take care not to insert the tool too far causing damage to the inside bore of the Module. Clean the bore of the Module if required by using a cotton swab soaked in Gun Cleaner.

**Figure 13. Mixing Module**

**Mixing Module Installation**

1. INSPECT THE GUN BLOCK- it is important for proper operation of the Spray Gun that the Gun Block is clean and free from damage.

2. INSTALL THE MODULE INTO THE GUN BLOCK- trigger the gun to OPEN position and hold. Carefully place the Module (tapered end first) over the Valving Rod and firmly seat in place into the Gun Block

3. INSTALL THE PCD BODY ONTO THE GUN BLOCK- first insert the Front Packing into the PCD Body. Thread the body into the Gun Block by hand. Release the trigger to align the components. Use the 5/8” wrench to tighten the PCD Body snugly onto the Gun Block.

4. DISCONNECT THE AIR SUPPLY- Disconnect the Air Hose from the Quick Disconnect Fitting on the Air Supply Hose. Turn the Forward Stop 1 to 2 turns clockwise.

5. INSTALL PATTERN CONTROL DISC (Figure 14)- Place the Pattern Control Disc onto the PCD Body. Apply lubricant to the threads, install the PCD Retainer onto the PCD Body, and tighten using an adjustable wrench. Slightly loosen the PCD Retainer. Use the 3/8 wrench to orient the fan slot as required and retighten the PCD Retainer.

6. ADJUST THE FORWARD STOP- Follow Steps 3 through 6 in the Forward Stop Adjustment section of this manual.
NOTE: When installing a fan tip, the orientation of the fan slot must be selected. Usually either to the horizontal or vertical position; however, the selection is determined solely by operator preference.

**FIGURE 14. PATTERN CONTROL DISC ASSEMBLY**

7. INSTALL THE AIR CAP—determine that the Air Cap O-Ring is in place. Thread the Air Cap onto the PCD Retainer and tighten by hand.

**WARNING:** OVER-TIGHTENING OF THE AIR CAP OR HARDENING OF MIXED MATERIAL CAN CAUSE THE PCD RETAINER TO STICK INSIDE THE AIR CAP DURING REMOVAL. TO HELP PREVENT THIS, APPLY A LIBERAL COATING OF GREASE TO THE THREADS OF BOTH DURING ASSEMBLY.

8. ADJUST AIR CAP AIR SUPPLY.

9. OPEN BOTH MANUAL VALVES.

10. ADJUST VALVING ROD STOP TO THE OPEN POSITION.

11. TEST SPRAY.

**Pattern Control Disc Cleaning**

1. SET THE REAR STOP TO THE SERVICE POSITION.

2. CLOSE BOTH MANUAL VALVES.

3. TURN OFF AIR TO THE AIR CAP.

4. CLEAN THE PCD -
   (FIGURE 15) use a cotton swab soaked in Gun Cleaner to wipe the external surface of material build-up. Light scrubbing with the Impinger Cleanout Brush may also be required.

   Trigger the Gun to the "SERVICE" position and clean the Orifice area.

**FIGURE 15. CLEAN THE PCD**
Screen Screw Service

1. REMOVE THE SCREEN SCREW (Figure 17) — holding the opposite side of the gun block to minimize stress to the coupling block screw, use a 7/8” wrench to remove the Screen Screw Assembly. Disassemble the Screen and Check Valve from the Screen Screw and clean all parts in Gun Cleaner.

2. REINSTALL THE PARTS- install the Screen Screw in a vertical position so that the Check Valve remains in its proper place during assembly. Snug the Screen Screw with a 7/8”.

Flushing Procedure

The Gun Block must be thoroughly flushed with Gun Cleaner before removing the Valving Rod or mixing components from the Gun Block. In this way, the residual left from the two components will be completely diluted with Gun Cleaner and will not react with one another when the Gun Block components are removed.

This procedure makes use of the optional Gun Service Kit and is the recommended procedure for several reasons:

1) The cleaning is more efficient and uses less Gun Cleaner.
2) The gun does not have to be disassembled.
3) It can be used as a quick and efficient end of day procedure.

WARNING: TO AVOID STATIC SPARKING WHICH COULD RESULT IN FIRE OR EXPLOSION, BE SURE ALL EQUIPMENT IN THE FLUSHING OPERATION IS PROPERLY GROUNDED. DO NOT FLUSH ON OR NEAR FOAMED OR COATED SURFACES.

WARNING: WHEN SERVICING OR OPERATING THE GX-7, SUFFICIENT PROTECTIVE CLOTHING MUST BE WORN TO PREVENT PROLONGED SKIN CONTACT WITH THE CHEMICALS OR SOLVENTS USED IN OR WITH THE GUN.

APPROVED SAFETY GLASSES OR GOGGLES MUST ALWAYS BE WORN WHEN SERVICING OR OPERATING THE GX-7.

1. SET THE TWO POSITION STOP TO THE SERVICE POSITION.
2. CLOSE BOTH MANUAL VALVES.
3. **REMOVE THE GUN FROM THE COUPLING BLOCK** - use the 5/16” Spintite Wrench and remove the Coupling Block Mounting Screw. Separate the gun from the Coupling Block and wipe clean the face of the Coupling Block to prevent material build-up.

   Attach the Service Block from the Gun Service Kit to the Gun Block. Determine that the flushing system is pressurized [recommend 40 psi (3 bars) minimum] and open the Manual Valves.

4. **SET THE TWO POSITION STOP TO THE OPEN POSITION** - aim the gun into a waste receptacle for proper disposal and trigger the gun to open for approximately 5 seconds or until the Gun Cleaner appears clear.

   Close the Manual Valves and quickly trigger the gun to relieve the pressure in the Gun Block.

5. **REMOVE THE SERVICE BLOCK** - continue with the disassembly procedure or mount the gun to the Coupling Block as appropriate.

**ALTERNATE PROCEDURE**

1. **SET THE TWO POSITION STOP TO THE SERVICE POSITION.**

2. **CLOSE BOTH MANUAL VALVES**

3. **REMOVE THE R-SCREEN SCREW** - use an adjustable wrench to loosen the Screen Screw and continue unthreading it by hand.

   Use a Flush Can to thoroughly flush the Screen Screw and Screen Screw Cavity.

4. **REMOVE THE A-SCREEN SCREW** - use an adjustable wrench to loosen the Screen Screw and continue unthreading it by hand.

   Use a Flush Can to thoroughly flush the Screen Screw and Screen Screw Cavity.

5. Service Gun - following servicing procedure
## APPENDIX

### Specifications

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<th><strong>US</strong></th>
<th><strong>Metric</strong></th>
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<td><strong>Maximum Output:</strong></td>
<td>40 lbs/min</td>
<td>18 kg/min</td>
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<td><strong>Minimum Output:</strong></td>
<td>3.50 lbs/min</td>
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<td><strong>Max. Operating Pressure:</strong></td>
<td>3500 psi</td>
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<td><strong>Air Supply:</strong></td>
<td>100-125 psi</td>
<td>7-9 bar</td>
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<td><strong>Mixing:</strong></td>
<td>Internal Impingement; Airless Atomization Solvent Free, Mechanically Self-Cleaning</td>
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<tr>
<td><strong>Weight:</strong></td>
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# INSTRUCTION MANUAL DISCREPANCY REPORT

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